

July 15, 2010 8:54:18 AM



PRELIMINARY ISSUE

Page 1

Accept

[illegible]**Setup Start**

Stop

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466
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Cust Item ID:

Required Date: 22/07/2010 **Req'd Qty:** 2.00

Customer:

Reference: 60-103-15



Run Start

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Date: _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D4101	PA4 <i>Am 10.07.15</i>

100	Cut blanks as per folio	0.00
-----	-------------------------	------

2

[illegible]

5.00" LONG

Jeaspa Bandusaw 5.00 BONG 17-10-2017 11:11

110 0.00 *2011/1/1*

CMR 10/07/18

[illegible]

HAAS CNC vertical machine #1

HAAS CNC vertical machine #1 1mm as per dwg and 1.000 17047

DEBURR

120	QC2- Inspect parts off machine FAI/FAIB	0.00	<i>CHK 10/07/18</i>
-----	---	------	---------------------

2

	Memo	0.00	
--	------	------	--

Quality Control Memo

Quantity Control

Work Order ID 60590

July 15, 2010 8:54:18 AM



Page 2

Item ID: D4101-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 15/07/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 22/07/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

- inspector to pass
Dry only
8/10/2010

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 BR 10-7-19

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7/11 10/07/19

2 0

Work Order ID 60590

July 15, 2010 8:54:18 AM



Page 3

Item ID: D4101-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 15/07/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 22/07/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location:

*ProL
Shelf*

0.00



Packaging

Memo

0.00

Packaging

Jul 10.07.21

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*test part test
10.07.22 10.07.30*

*MF
10-7-21*

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

Picklist Print

Page 1

July 15, 2010 8:54:16 AM

Work Order ID: 60590



Parent Item: D4101-1



Parent Item Name: Bracket

Start Date: 15/07/2010

Required Date: 22/07/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-07-11 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X04.50 0		Purchased	No			100	f	20.5000	0.416	0.875789			



6061T6 Bar 2.00 x 4.500

Location

Loc Qty

Loc Code

MAT08

20.5

112330

20.5



18757 ml 10/07/17

DART AEROSPACE LTD		Work Order: 60596
Description: BRACKET		Part Number: D4101-1
Inspection Dwg: D4101 Rev: PA4		Page 1 of 1

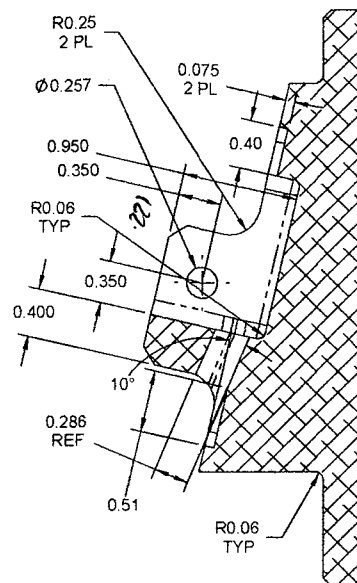
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

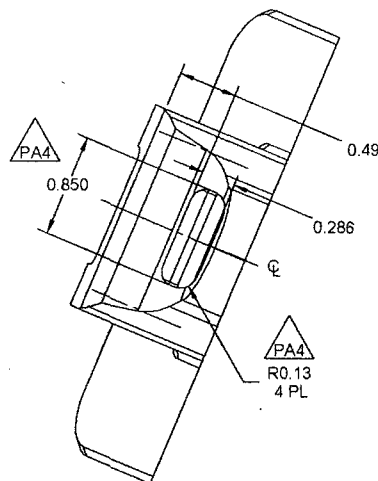
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.06 X 45°	±.030 X ± 1/2°	.075 X 45°	—		vern	
4.75	±.030	4.750	—		"	
4.00	±.030	4.00	—		"	
R.13	±.013	R.125	—		R-G	
grain dir.	N/A	—	—		visual	
.30	±.030	.302	—		vern	
1.02	±.030	1.018	—		"	
.94	±.030	.938	—		"	
.78	±.030	.776	—		"	
1.18	±.030	1.178	—		"	
.13 X 45°	±.030 X ± 1/2°	.132 X 45°	—		"	
.68	±.030	.679	—		"	
.60	±.030	.601	—		"	
.28	±.030	.282	—		"	
R.06	±.030	R.060	—		R-G	
.57	±.030	.570	—		vern	
.400	±.010	.396	—		"	
.350	±.010	.357	—		"	
.350	±.010	.349	—		"	
.950	±.010	.948	—		"	
Ø.257	±.006	Ø.261	—		"	
.40	±.030	.400	—		"	
.075	±.010	.073	—		"	

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 10/07/18	Date: 10/07/18	Date:	N/A

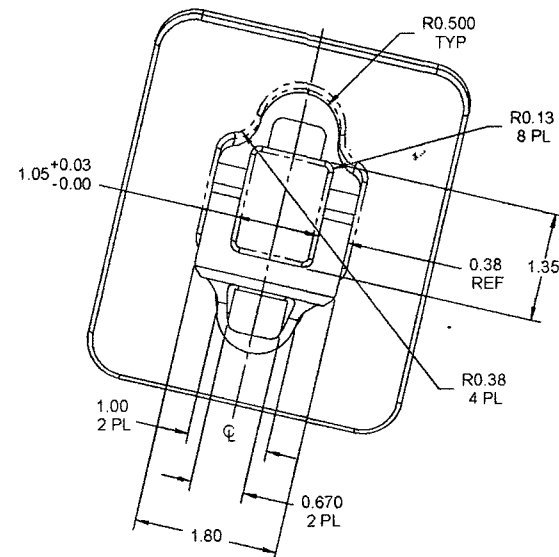
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



SECTION A-A C7-2
SCALE 2X



VIEW B-B C4-2
SCALE 2X

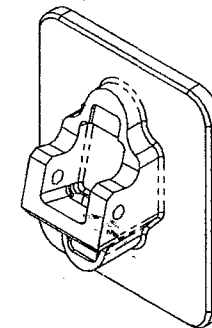
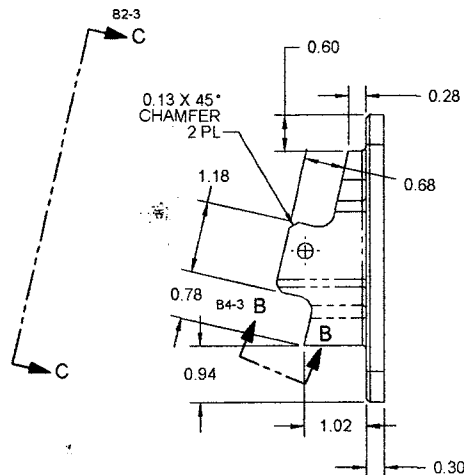
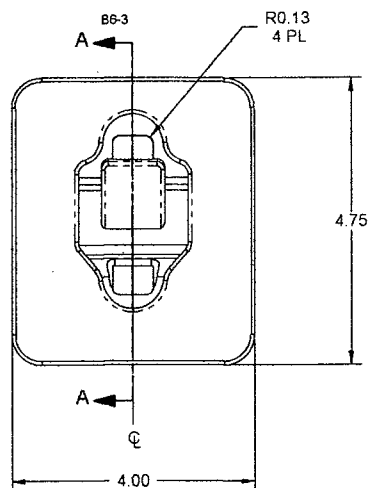
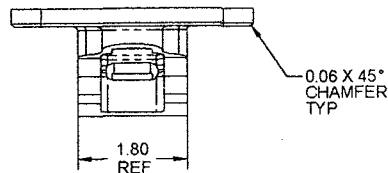


VIEW C-C D4-2
SCALE X1.5

PRELIMINARY ISSUE

~~10~~ 10.07.12

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PA4
MFG. APPR.		D4101	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		PRE-FLIGHT STEP ASSEMBLY	NTS
DATE	10.07.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4101-1 BRACKET



PRELIMINARY ISSUE

10.07.12

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.85 lbs



DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA4
MFG. APPR.		D4101	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		PRE-FLIGHT STEP ASSEMBLY	NTS
DATE	10.07.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Receiving Report

Date: 9/1/31

Batch No: M112330

Supplier: MAGNA

Dart P/O: 10134

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ N/A ☐
 Work Order 010134 N/A ☒

Discrepancies

Discrepancies						
Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M6 Jet 6300	200 to 400	20	24	0	4	

Initials of receiver (if shipment OK) Level 12

Production/Admin: A.07.31
 Date
 Received/Costing 10134
 Initial h

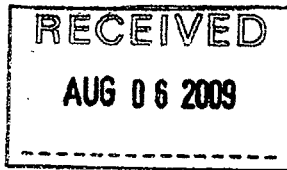
Location _____



Magna Stainless
5775 Kieran St, Saint-Laurent QC H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

INVOICE

Pg 1 of 1 I014834



SOLD TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY , ON
K6A 1K7

SHIP TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY , ON
K6A 1K7

MTR:Y

INVOICE DATE:	07/31/09
ORDER DATE:	07/27/09
SHIP DATE:	07/31/09
ORDER NUMBER:	W016332
PURCHASE ORDER:	PO10134

Currency	Sales Person	Ship Via	F.O.B.	Terms
CANADIAN DOLLARS	ERYCK BLAIS	NIR:R-557065-1	PREPAID	NET 30 DAYS

Ln	Back Ordered	Ordered	Unit	Description	Shipped	Price Per	Value
		2	PC	ALUMINUM - LB 6061-T6 2" X 4 1/2" X 12' L029903 2 PC/260 LB	2 UN	495.00	990.00

08/03/09 10:46:48

Merchandise:	990.00
Surcharges:	
No Tax Costs:	
GST	49.50
Total Due:	1,039.50

Title to the goods sent out on this invoice remains with Magna Stainless Div of CSM ULC until such time as this invoice has been paid in full. Unless otherwise noted terms are 30 days. Interest accrues on all overdue accounts at the rate of 1.5% per month compounded monthly.

Q.S.T. # 1213236471
G.S.T. # 881565899 RT0001

Purchase Order Receipt Listing

July 31, 2009 2:24:52 PM

Page 1 of 1

All amounts are calculated in domestic currency.

All Vendors PO ID po10134 All Receipt Dates All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID/Vendor Name		VC-MAG002	Magna Stainless								
PO10134	I		M6061T6B2.000X04. f		7/31/09	7/31/09	24.0000	\$45.00	0.0000	0	\$1,080.00
			500								
CAD	No		6061T6 Bar 2.00 x f		20.0000	Stores		\$1,080.00	0.0000	0	
			4.500								
			112330								

Total Received Quantity:	24.0000
Total Qty to Inspect (PO U/M):	0.0000
Total Reject Quantity:	0.0000
Total Receipt Value:	\$1,080.00
Total Balance Due Quantity:	0.0000

**Magna Stainless**

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

PACKING LIST

I014834

Page: 1 of 1

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY, ON
K6A 1K7
Contact: LINDA

HAWKESBURY, ON
K6A 1K7
Ship Terms: PREPAID



SPECIAL INSTRUCTIONS

Currency	Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS	ERYCK BLAIS	(613) 632-5200	(613) 632-1053	PO10134	
Sales Order	Terms	Ship Via	Date Ordered	Date Required	Date Shipped
W016332	NET 30 DAYS	NIR:R-557065-1	07/27/09	08/03/09	07/31/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
2		PC	ALUMINUM - LB 6061-T6 2" X 4 1/2" X 12" ✓ 260 LB / 2 PC <i>(9/7/31)</i>	L029903	200904833	2
Bundles: 1				Total Weight:		260 LB

Received by: _____ Date: _____ Signature: _____



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO10134

Purchase Order Date 7/27/09

PO Print Date 7/27/09

Page Number 1 of 1

Order From :

VC-MAG002

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

Contact Name

Vendor Phone 800 363 6646

Vendor Fax 514 339 1105

Vendor Account Nbr

Buyer

Linda Lacelle

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Ship To :

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6061T6B2.000X04.500	6061T6 Bar 2.00 x 4.500	7/31/09 Yes	20.00	Yours ppd	\$45.0000	\$900.00

Special Inst: 6061-T6(OR 6061-
T651/T6510/T6511/T62)BAR
PER AMS-QQ-A-225/8(OR
AMS4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS4160)

PO Total:

\$900.00

MATERIAL CERTIFICATION
REQD UPON DELIVERY

Change Nbr: 1

Change Date: 7/27/09

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

L Lacelle

From: Eryck Blais [eblais@magnastainless.com]
Sent: July 27, 2009 11:03 AM
To: 'L Lacelle'
Subject: RE: rfq

hi linda

2 PCS 495.00 EACH
DELAY 5-7 DAYS
THANK YOU
ERYCK

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Friday, July 24, 2009 10:10 AM
To: Eryck Blais
Subject: rfq

20' x 6061T6 Bar 2.00 x 4.500

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd

7/27/09



SERVICE CENTER METALS
5850 Quality Way
Prince George, VA 23875

7006183
CERTIFIED INSPECTION REPORT AND TEST RESULTS
FOR EXTRUDED PRODUCTS

BILL TO

SHIP TO

MANIFEST NUMBER

80320

DIE NUMBER

RB0369

DATE OF SHIPMENT

5/12/2009

CUSTOMER PO

P90415DS006 CT

ALLOY / TEMPER

(6061-T6511)

SALESPERSON

David Schroeder

CUSTOMER PART NUMBER

RB0369

DESCRIPTION

(SCRB 2.000x4.500)

OUR ORDER NUMBER

905110

ITEM

3

CERTIFICATION

ASTM-B221-08 Stencil

SPECIFICATION

(AMS-QQA-200/8)

We hereby certify that the material covered by this report has been inspected in accordance with the most recent certification revision, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material met the composition limits and had the mechanical properties shown. SCM extrusions are manufactured in the USA from ingot melted and cast in the United States or Canada.

Items produced and certified as 6061-T6511 also meet the requirements of 6061-T6

Mechanical Properties

Lot No.	Test No.	Test Date	Ultimate Tensile Strength (KSI)	Yield Strength (KSI)	Percent Elongation
(200904833)	1	05/09/09	51.9	46.9	19.9

807/07/31

Chemical Composition for Alloy 6061

Alloy		Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Other:	Each	Total	Al	Melted In
6061	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15		Remainder	
	Min	0.40	-	0.15	-	0.8	0.04	-	-					

United States of America